

Date: Wednesday, 03/06/2009 8:50:51 AM  
 User: Melanie Fauteux

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: RATCHET LUG
Job Number	: 48345		
Estimate Number	: 13994		
P.O. Number	:	Part Number	: D39547 <b>FR</b>
This Issue	: 03/06/2009 S.O. No. :	Drawing Number	: D3954 REVA
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	:	Material	:
Written By	:	Due Date	: 03/06/2009 Qty: 1 Um: Each
Checked & Approved By	: <i>mf</i> 09-06-03		
Comment	: Est Rev:A 09-06-02 new issue EC verified by:DD		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304B1500X1500	304 bar 1.50 X 1.50
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Comment: Qty.: 0.5250 f(s)/Unit Total: 0.5250 f(s)

~~304/316 Bar 1.50" X 1.50"~~

Batch: *1110740*

*mf* 09/06/03

①

2.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE  
 mill to size

*mf* 09/06/03

①

3.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg

Dwg Rev: *A*

Prog Rev: *A*

*B963*

①

2-Deburr if necessary

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*B963*

①

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*mf* 09-06-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 03/06/2009 8:50:51 AM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RATCHET LUG

Job Number: 48345

Part Number: D39547

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

*M 102391*

START TIME:

*10:30*

OVEN TEMPERATURE:

*320°C*

FINISH TIME:

*11:00*

*BR 09-06-4*

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*1029 06 01 @*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify as per dwg and Stock

Location: \_\_\_\_\_

*1304 06 01 @*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*09/06/05*

Job Completion



*mf 09-06-04*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

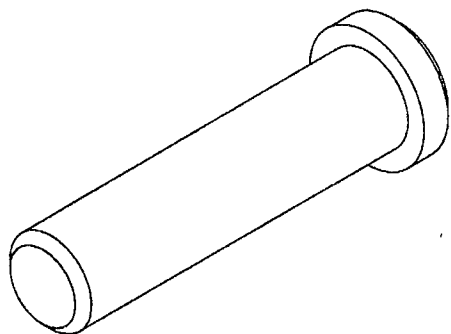
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

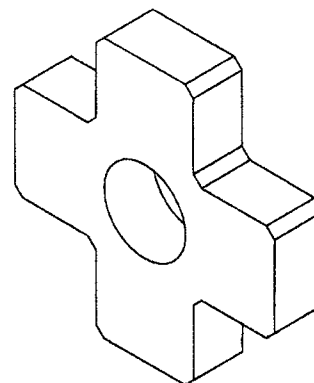
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

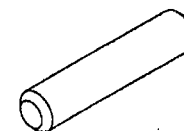




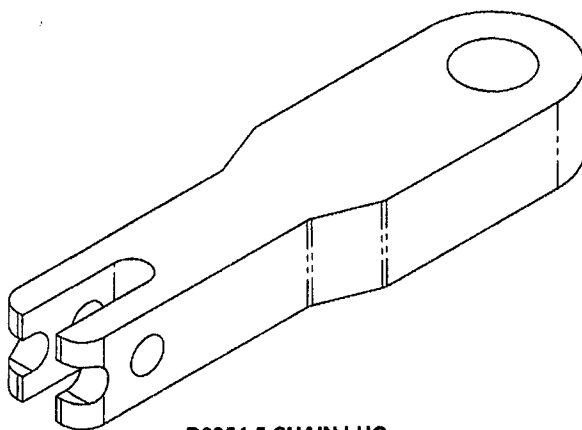
**D3954-1 GWT PIN**



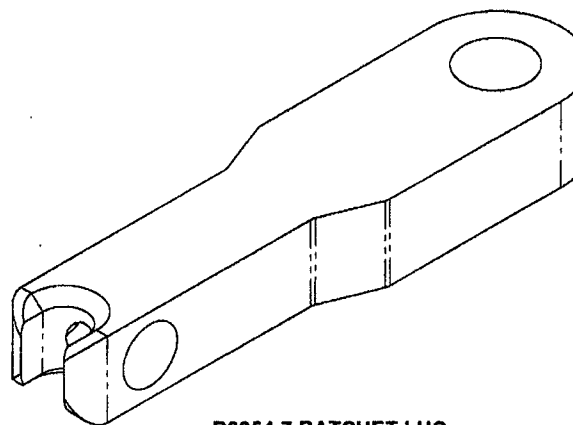
**D3954-3 GWT KNOB**



**D3954-9 GWT CHAIN PIN**






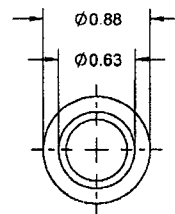
**D3954-5 CHAIN LUG**



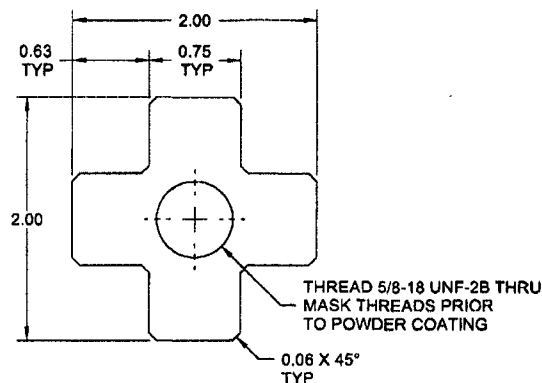
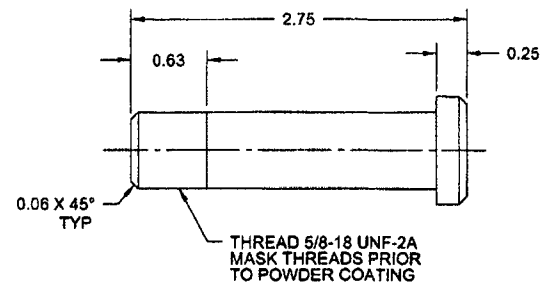
**D3954-7 RATCHET LUG**

48345  
**RELEASED**  
09/05/26

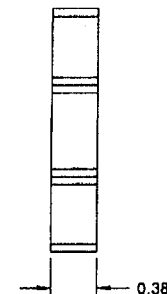
A		NEW ISSUE		AJS	09.05.26
REV.		DESCRIPTION		BY	DATE
DESIGN	AJS/DSTOW	DART AEROSPACE LTD			
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA			
CHECKED		DRAWING NO.	REV. A		
MFG. APPR.		D3954	SHEET 1 OF 3		
APPROVED		TITLE	SCALE		
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT NTS			
DATE	09.05.26	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



**D3954-1 GWT PIN**



**D3954-3 GWT KNOB**



**NOTES:**

1) MATERIAL -1: AISI 303/304 STAINLESS STEEL ROUND BAR  
REF DART SPEC M303/304R

-3: AISI 303/304 STAINLESS STEEL SHEET  
PER AMS 5513 OR AMS 5524  
REF DART SPEC M303/304S

OR: AISI 303/304 STAINLESS STEEL BAR  
REF DART SPEC M303/304B

2) FINISH: POWDER COAT FIRE RED (4.3.6.10) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER

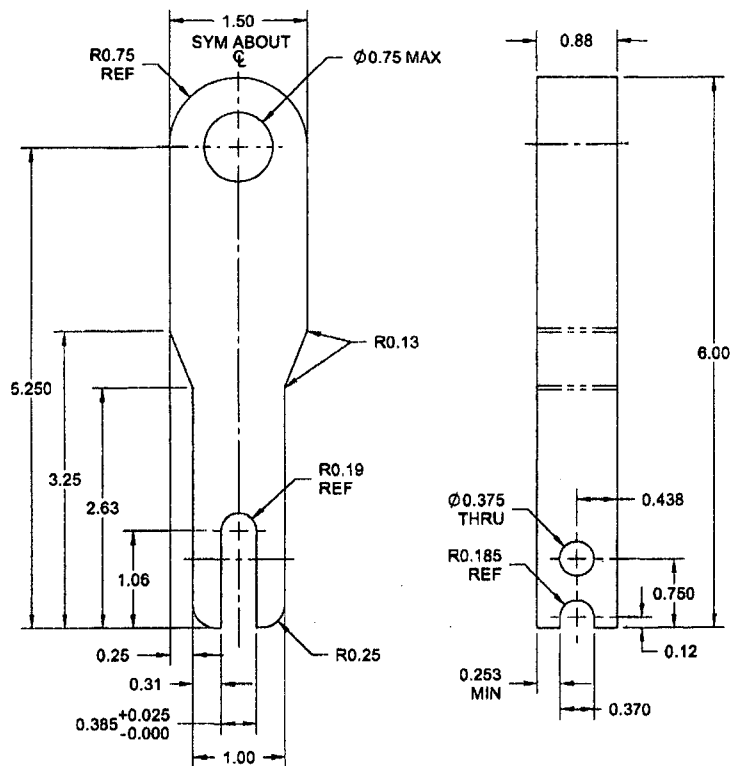
7) WEIGHT -1: 0.26 lbs

-3: 0.23 lbs

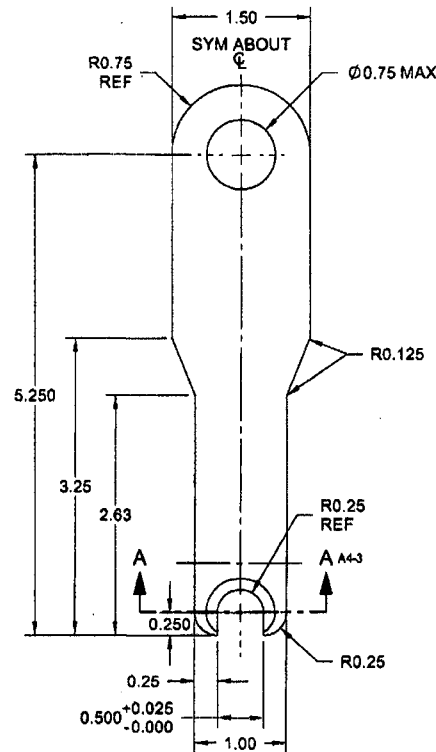
48345

**RELEASED**  
09/05/26

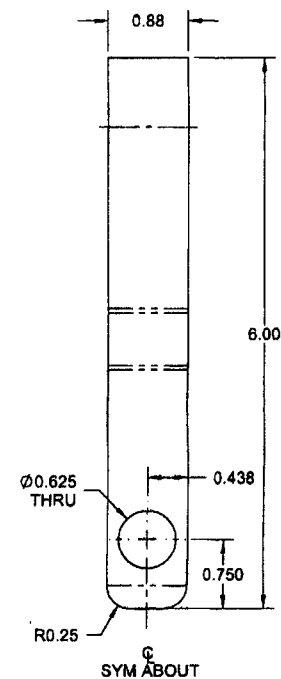
DESIGN	AJS/DSTOW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3954	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS
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**D3954-5 CHAIN LUG**



**D3954-7 RATCHET LUG**



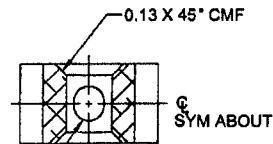
**D3954-9 GWT CHAIN PIN**

**NOTES:**

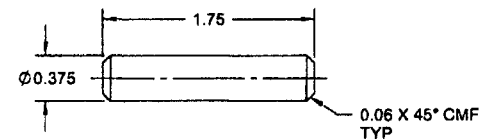
1) MATERIAL -5/-7: AISI 303/304 STAINLESS STEEL BAR  
REF DART SPEC M303/304B

-9: AISI 303/304 STAINLESS STEEL ROUND BAR  
REF DART SPEC M303/304R


- 2) FINISH -7 ONLY: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -5/-7: 1.56 lbs EACH  
-9: 0.05 lbs



**SECTION A-A** C3-3



**RELEASED**  
07/08/02

DESIGN	AJS/DSTOW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3954	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS
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